

Work Order ID 73983

Tuesday, September 20, 2011 10:24:08 AM



Page 1

Item ID: D206-628-023

Accept



Setup Start



Revision ID:

Item Name: Heli-Access-Step LH

Stop



Start Date: 9/20/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 10/4/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: MF Date: 11-09-20

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

100



DOCUMENT CONTROL

0.00

DC

Memo

0.00

Document Control

Photocopy blue file and type labels as per PPP D206-628-023 CHG 003

8/11/10/25

8/11/10/25 11-9-29
(2)

110



Pick Kit

0.00

Packaging

Memo

0.00

Packaging

8/11/10/25 11-09-29

120



QC4- 100% Inspect kits for completeness

0.00

QC

Memo

0.00

Quality Control

8/11/10/25

(2)

LH

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

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Page 2

Tuesday, September 20, 2011 10:24:08 AM

Item ID: D206-628-023

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step LH

Start Date: 9/20/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 10/4/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130 | Packaging | 0.00 | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | Identify and pack for shipping as per PPPD206-628-023 Location: <u>71</u> PPP Rev: <u>11</u> | | | | | | | | |
| 140 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

Sep 11-10-26 22

11/10/27

me

11-10-28

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, September 20, 2011 10:24:05 AM

Page 1

Work Order ID: 73983

Parent Item: D206-628-023

Parent Item Name: Heli-Access-Step LH

Start Date: 9/20/2011


Required Date: 10/4/2011

Start Qty: 2.00


Required Qty: 2.00

Comments: IPP Rev:D As Per Ecn766 06-01-06 JLM
IPP Rev:E as per ecn 1118 08-02-05 DD verified by:EC
IPP rev F ncr 09-004 09.01.09 EC verified by:DD


| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

| | | | | | | | | | | | | | |
|--|--|-----------|----|--|--|-----|------|-----------|---|---|--|--|--|
| AN3C4A | | Purchased | No | | | 120 | Each | 2,700.000 | 3 | 6 | | | |
|  | | | | | | | | | | | | | |
| BOLT | | | | | | | | | | | | | |

| Location | Loc Qty | Loc Code |
|---------------|---------|----------|
| ST350 | 2700 | |
| 117313 | 2 | |
| 117688 | 5 | |
| 117872 | 22 | |
| 118112 | 16 | |
| <u>118451</u> | 969 | |
| 118628 | 186 | |
| 118706 | 500 | |
| 118838 | 1000 | |

| | | | | | | | | | | | | | |
|--|--|-----------|----|--|--|-----|------|----------|---|---|--|--|--|
| AN4C14A | | Purchased | No | | | 120 | Each | 138.0000 | 4 | 8 | | | |
|  | | | | | | | | | | | | | |
| Bolt | | | | | | | | | | | | | |

| Location | Loc Qty | Loc Code |
|---------------|---------|----------|
| ST358 | 138 | |
| <u>118706</u> | 138 | |

| | | | | | | | | | | | | | |
|--|--|-----------|----|--|--|-----|------|----------|---|----|--|--|--|
| AN4C15A | | Purchased | No | | | 120 | Each | 185.0000 | 8 | 16 | | | |
|  | | | | | | | | | | | | | |
| Bolt | | | | | | | | | | | | | |

| Location | Loc Qty | Loc Code |
|---------------|---------|----------|
| ST358 | 185 | |
| 115835 | 2 | |
| <u>117795</u> | 33 | |
| 118628 | 50 | |
| 118706 | 100 | |

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

Page 2

Tuesday, September 20, 2011 10:24:05 AM

Work Order ID: 73983

Parent Item: D206-628-023

Parent Item Name: Heli-Access-Step LH

Start Date: 9/20/2011

Required Date: 10/4/2011

Start Qty: 2.00

Required Qty: 2.00

AN960C416L WASHER Purchased No

120 Each

0.0000 24 48



WASHER

m117291 48x



SP

D2731-7 Manufactured No

120 Each

76.0000 4 8



Mounting Lug



SP

Location

Loc Qty

Loc Code

ST468A

50

71860

50

ST470

26

62929

2

66427

24

D2732 Manufactured No

120 f

521.8981 2 4



Rubber Extrusion



SP

Location

Loc Qty

Loc Code

ST410

521.89811

64283

23.02811

70987

498.87

4

(D2732-030) Cut (8) at 3.00"

D2842-041 Manufactured No

120 Each

0.0000 1 2



Step Assembly, 206 Float

D2844-1 Manufactured No

120 Each

9.0000 2 4



Arm



SP 11-09-29

Location

Loc Qty

Loc Code

ST263

9

70541

1

73328

8

4x

Tuesday, September 20, 2011 10:24:05 AM

Shop Packet Print

Page 2

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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| | | | | | | | |
| | | | | | | | |

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Picklist Print

Tuesday, September 20, 2011 10:24:05 AM

Work Order ID: 73983

Parent Item: D206-628-023

Parent Item Name: Heli-Access-Step LH

Start Date: 9/20/2011

Required Date: 10/4/2011

Start Qty: 2.00

Required Qty: 2.00

D2844-3 Manufactured No

120 Each

4.0000

1

2



Arm



SP

Location

Loc Qty

Loc Code

ST266

4

66822

4

2x

D3394-043

Manufactured No

120 Each

49.0000

4

8



Lug Assembly



SP

Location

Loc Qty

Loc Code

ST475

49

62930

2

62976

14

66429

33

1K

7x

MS21043-4

Purchased No

120 Each

1,103.000

12

24



Nut



SP

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

1063

117793

470

118378

93

118686

500

24x

NAS1149C0363R

Purchased No

120 Each

4,027.000

3

6



Washer



SP 11-09-29

Location

Loc Qty

Loc Code

ST297

4027

114742

4027

6x

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Tuesday, September 20, 2011 10:24:05 AM

Work Order ID: 73983

Parent Item: D206-628-023

Parent Item Name: Heli-Access-Step LH

Start Date: 9/20/2011

Required Date: 10/4/2011

Start Qty: 2.00

Required Qty: 2.00

NAS1515H3

Purchased.

No

120

Each

136.0000

3

6



Washer



SP

Location

Loc Qty

Loc Code

ST277

136

116373

6

117460

8

118078

6

118384

116

Cox

NAS1515H4L

Purchased

No

120

Each

378.0000

24

48



WASHER



SP 11-09-29

Location

Loc Qty

Loc Code

FG

12

103691

12

ST277

366

118709

366

48x

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

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| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

5.2 D206-628-013/-014/-023/-024/-033/-034 FLOAT COMPATIBLE DART HELI-ACCESS-STEPS™ PARTS LIST

| Qty -013 | Qty -014 | Qty -023 | Qty -024 | Qty -033 | Qty -034 | Part Number | Description |
|-------------|-------------|-------------|-------------|-------------|-------------|---------------|------------------------------------|
| X | | | | | | D206-628-013 | 206 A/B FLOAT STEP INST. LH |
| | X | | | | | D206-628-014 | 206 A/B FLOAT STEP INST. RH |
| | | X | | | | D206-628-023 | 206 L/L1/L3/L4 FLOAT STEP INST. LH |
| | | | X | | | D206-628-024 | 206 L/L1/L3/L4 FLOAT STEP INST. RH |
| | | | | X | | D206-628-033 | 407 FLOAT STEP INST. LH |
| | | | | | X | D206-628-034 | 407 FLOAT STEP INST. RH |
| | | | | | | | |
| | | | | 4 | 4 | D2731-3 | MOUNTING LUG |
| 4 | 4 | 4 | 4 | | | D2731-7 | MOUNTING LUG |
| 8 | 8 | 8 | 8 | 8 | 8 | D2732-030 | RUBBER CUSHION |
| 1 | | | | | | D2841-041 | FLOAT STEP ASSEMBLY LH |
| | 1 | | | | | D2841-042 | FLOAT STEP ASSEMBLY RH |
| | | 1 | | 1 | | D2842-041 | FLOAT STEP ASSEMBLY LH |
| | | | 1 | | 1 | D2842-042 | FLOAT STEP ASSEMBLY RH |
| | | 2 | 2 | 2 | 2 | D2844-1 | ARM |
| | | 1 | 1 | 1 | 1 | D2844-3 | ARM |
| 2 | 2 | | | | | D2845 | ARM |
| | | | | 4 | 4 | D3394-041 | MOUNTING LUG |
| | | | | 4 | 4 | *D3394-1 | *LUG |
| 4 | 4 | | | 8 | 8 | *MS35489-93 | *GROMMET |
| 4 | 4 | 4 | 4 | | | D3394-043 | MOUNTING LUG |
| 4 | 4 | 4 | 4 | | | *D3394-3 | *LUG |
| 8 | 8 | 8 | 8 | | | *MS35489-93 | *GROMMET |
| 1 | 1 | | | | | D4064-041 | MOUNTING LUG |
| 1 | 1 | | | | | *D4064-1 | *LUG |
| 2 | 2 | | | | | *MS35489-93 | *GROMMET |
| | | | | | | | |
| 2 | 2 | 3 | 3 | 3 | 3 | AN3C4A | BOLT |
| 4 | 4 | | | | | AN4C13A | BOLT |
| 4 | 4 | 4 | 4 | 8 | 8 | AN4C14A | BOLT |
| 4 | 4 | 8 | 8 | 4 | 4 | AN4C15A | BOLT |
| 2 | 2 | 3 | 3 | 3 | 3 | NAS1149C0363R | WASHER (OR AN960C10) |
| 16 | 16 | | | | | NAS1149C0463R | WASHER (OR AN960C416) |
| 8 | 8 | 24 | 24 | 24 | 24 | NAS1149C0432R | WASHER (OR AN960C416L) |
| 24 | 24 | 24 | 24 | 24 | 24 | NAS1515H4L | WASHER |
| 12 | 12 | 12 | 12 | 12 | 12 | MS21043-4 | NUT |
| 2 | 2 | 3 | 3 | 3 | 3 | NAS1515H3 | WASHER |

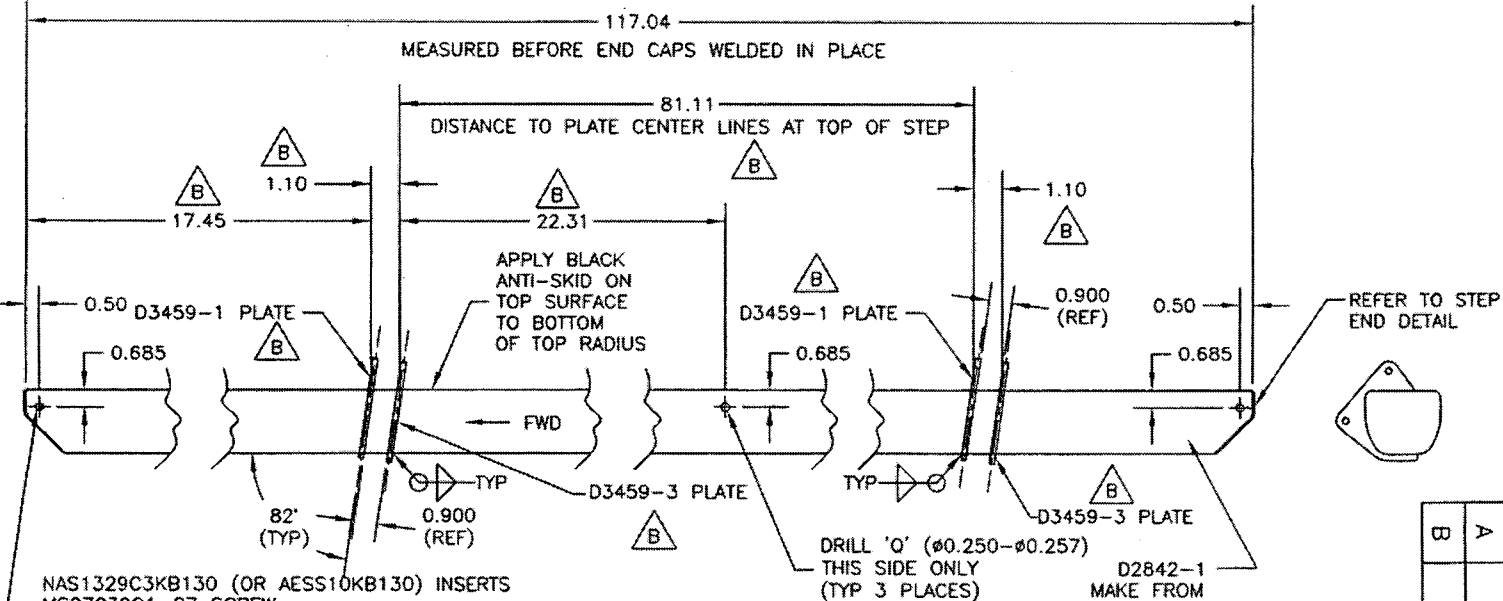
*DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE

5.3 QUICK RELEASE PIP PIN KIT

| Qty -011 | Part Number | Description |
|-------------|-------------|---------------------------|
| X | DSI9235-011 | QUICK RELEASE PIP PIN KIT |
| | | |
| 4 | BLRS-020 | QUICK RELEASE PIN |



| DESIGN | KE | DRAWN BY | PH | DART AEROSPACE USA, INC. |
|---------|--------------------|----------|------------------------------|--------------------------|
| CHECKED | <i>[Signature]</i> | APPROVED | <i>[Signature]</i> | PORT HADLOCK, WA |
| DATE | 05.09.23 | TITLE | D2842 | REV. B |
| | | | 206L/407 FLOAT STEP ASSEMBLY | SHEET 1 OF 1 |
| | | | NEW ISSUE | SCALE |
| | | | RE-DESIGN, ADD D3459-1/-3 | NTS |

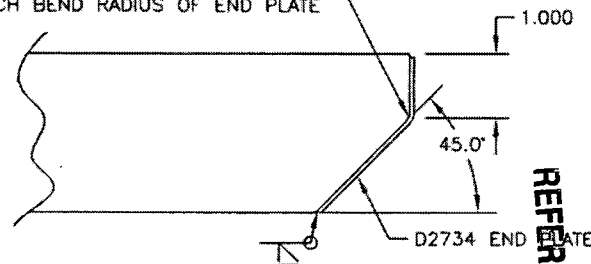


**D2842-041 LH STEP ASSEMBLY (SHOWN)
D2842-042 RH STEP ASSEMBLY (OPPOSITE)**

D2842-041/-042 FLOAT STEP ASSEMBLY PARTS LIST

| QTY | QTY | PART NUMBER | DESCRIPTION |
|------|------|------------------------------------|------------------|
| -041 | -042 | | |
| X | X | D2842-041 | LH STEP ASSEMBLY |
| | | D2842-042 | RH STEP ASSEMBLY |
| 1 | 1 | D2622-118 | EXTRUSION |
| 2 | 2 | D2734 | END PLATE |
| 2 | 2 | D3459-1 | PLATE |
| 2 | 2 | D3459-3 | PLATE |
| 3 | 3 | NAS1329C3KB130 (OR AESS10KB130) | INSERT |
| 3 | 3 | MS27039C1-07 | SCREW |
| 3 | 3 | NAS1515H3L | WASHER |
| 3 | 3 | AN960C10L | WASHER |

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE

REFERENCE ONLY

D2842-041/-042 FLOAT STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
8-11-14